Work Orde uly-18-12 1:22.	er ID 87383		*873	38.3*							Page 1	
tem ID: Revision ID:	D412-704-045		Accept	*N900	040	100)*	Setup	Start	*N:	S1*	
	Cable Assembly (212/214/412)								Stop	*N:	S2*	
tart Date: Required Date: Reference:	7/10/12 Start Qty: 4.00 8/03/12 Req'd Qty: 4.00	= ▼		Cust Item II Customer:	D:		,					
approvals:	Process Plan: <u>M</u> し QC:	Date: \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	Tooling: SPC (Y/N):		nte:			Run	Start Stop	171	R1* R2*	
equence ID/ Vork Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Re Qt	-	Reject Number	Insp. Stamp	<u> </u>
Draw Nbr	Revision Nbr											-
DSI9611 IIN D412-704	A C									*·*		
00			0.00								FF	-
100 Small Fab	Small Fab Memo		0.00				4		P			-10-02
mall Fab	Assembl	le as per dwg					•					
10	QC5- Inspect part co	mpleteness to step on W/O	0.00				1.6					
110 QC Quality Control	Memo		‱SmB 13.10.2	(00,3) MIO	\o 2		-					

DQA:	Date:	

NCR: Yes / No

									QA Closed:	Date	::		
Work Orde	r:				DISPOSITION			AGAINST DE	NST DEPARTMENT/PROCESS				
Part No					Rework Scrap Use-as-is Work Order Update	Scrap Machining Small F e-as-is Thermoforming Finishi			Pro Rec/Stor	Engineering Quality Other			
Root				Descr	iption of work order update	Initial	Ac	tion	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	ription	Date	Verification	QC Inspector		
ooc/Data quip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
ларргоveu]		<u> </u>	<u> </u>			FAULT CAT	EGORY		<u> </u>	<u> </u>	 		
Landin	g Gear			-	General	`				-			
	Bending Centre I Cracks	S Not Conce		o/s	Bend BOM/Route Broken/Damaged Burrs	_		/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled		
<u> </u>	Cuffs Heat Tro				Contamination Countersink	—	tenance		Part Moved Positioned V				
	Inspecti Ripples	on Strip in in Bend	Tube		Cut Too Short Drill Holes	Misre Offse			Power Loss/		Other		
	Torque	Waves in I	Extrusio	1	Drawing	Out o	f Calibration			······································			
	Turning	urning Sequence Finish				Out of Sequence							
	Wave/T	Wave/Twist in Tube Folio					de Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 87383 *87383* July-18-12 1:22:23 PM Item ID: D412-704-045 Accept *N900040100* Setup Start Revision ID: Stop Item Name: Cable Assembly (212/214/412) *4* Start Date: 7/10/12 Start Oty: 4.00 Cust Item ID: Required Date: 8/03/12 **Reg'd Otv:** 4.00 **Customer:** Reference: Run Process Plan: Date: Tooling: Date: Approvals: Stop Date: SPC (Y/N): Date: OC: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reiect Reject Number Work Center ID Description Qty Code Oty **Run Hours** Identify as per dwg & Stock Location: 57 323 0.00 120 *120* 0.00 Packaging Memo Packaging

130

OC21- Final Inspection - Work Order Release

0.00

130 OC

Memo

0.00

Quality Control

12/10/3 7 MF 12-10-03

Page 2

Insp.

Stamp

DQA: Date:

NCR: Yes / No

	·									QA Closed:	Date	:			
Work Orde	r·				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No.				Scrap Macl			Skid-tube Nachining oforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other				
NCR N	o				Use-as-is Work Order Update] '''		Large Fab	Composite	Nec/Stol	Supplier				
Root				Descri	ption of work order update	Initia	al	Act	tion	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chief E	Eng	Desc	ription	Date	Verification	QC Inspector			
Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training			,												
Unapproved												·			
					F.	AULT CA	ATEG	ORY							
Landin	g Gear				General					- 4	_	_			
-	Bending Centre No Cracks	ot Conce	ntric to	O/S	Bend BOM/Route Broken/Damaged	1	dwar	e on Incomplete		Ovalized Over/Under Part Incorre	 	Pressure/Forced Temperature/Cure Weld			
	Crushed/	Crimped.			Burrs	Inst	tructio	ons Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled			
	Cuffs				Contamination	Ма	inter	nance		Part Moved	_	_			
	Heat Trea	nt			Countersink	Mis	slabel	ed		Positioned V	Vrong				
	Inspection	n Strip in	Tube		Cut Too Short	Mis	read			Power Loss/	Surge	Other			
	Ripples in	Bend			Drill Holes	Offs	set			-					
	Torque Waves in Extrusion Drawing .				Out of Calibration										
	Turning Sequence Finish				Out of Sequence										
Γ	Wave/Twist in Tube Folio					Out	tside	Dimensions							

Picklist Print

July-18-12 1:22:22 PM

Work Order ID:

87383

Parent Item:

D412-704-045

Parent Item Name:

Cable Assembly (212/214/412)

Comments:

IPP Rev:B05.01.28 Added Figures 1-2KJ/RF

IPP Rev:C 08-10-08 as per revB DD verified by:EC

Start Date: 7/10/12

Required Date: 8/03/12

Page 1

Start Oty: 4.00

Required Otv: 4.00

IPP REV:D 12.05.10 per DSI 9611 DD verf:EC Component Item ID/ Replacement Mfg/ Last Unit of " Oty on Oty per Kit Total Date Status Bin Primary Route Oty Item Name Location Seq ID Measure Hand Issued Issued Item ID Purch Item Location Qty AN3-10A No 100 Each 80.0000 1 4 Purchased FF 12-10-02 Bolt Loc Oty Loc Code Location ST351 122800 80 117795 2 120873 78 100 Each 1.211.0000 AN3-5A Purchased No FF 12-10-02 Bolt Loc Qty Loc Code Location 122800 ST350 1211 115371 46 117423 121 119355 200 120187 338 121185 6 122416 500 AN960JD10 NAS1149D0363J 100 Each 0.0000 FF12-10-02 No Purchased 122378 Washer 122973 100 Each 0.0000 AN960JD10L NAS1149D0332J No Purchased FF 12-10-02 Washer 100 Each 9.0000 4 D3217-3 No FF 12-10-02 Manufactured Cable 80.5" Loc Code Location Loc Qty ST223 79806 83195 84429 100 Each 0.0000 D3257-1 Manufactured No F12-10-02 76164 Fitting

DQA:	Date:	

NCR: Yes / No

	•						· · · · · · · · · · · · · · · · · · ·		QA Closed:	Date	:	
Work Orde	r.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS		
	Part No. Scrap Use-as-is						Skid-tube Machining	Crosstube Small Fab	4	Water Jet	Engineering Quality	
NCR N	0				Work Order Update	Ineri	Thermoforming Finishing Rec/Store/Packaging Othe Large Fab Composite Supplier					
Root				Descr	iption of work order update	Initial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector	
Ooc/Data quip/Tooling Operator Material												
Setup												
Other		ļ						·				
Process							1					
Supplier	\dashv											
raining	-	j										
Jnapproved	_											
	1		1	1	F	AULT CATE	GORY	······································	1			
Landin	g Gear				General				 			
ſ	Bending			Γ	Bend	Grain			Ovalized		Pressure/Forced	
	. Centre l	Not Conce	ntric to	o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld	
[Crushed	/Crimped			Burrs	Instruc	tions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	Cuffs				Contamination	Maint	enance		Part Moved			
	Heat Tre	eat		Γ	Countersink	Mislab	eled		Positioned V	Vrong	•	
Ī	Inspecti	on Strip in	Tube		Cut Too Short	Misrea	ıd .		Power Loss/	'Surge	Other	
	Ripples	in Bend			Drill Holes	Offset		<u></u>	_	_		
	Torque	Waves in I	Extrusio	n $lacksquare$	Drawing	Out of	Calibration					
	Turning Sequence Finish				Out of	Sequence						
	Wave/T	wist in Tu	be		Folio	Outsid	e Dimensions					

July-18-12 1:22:22 PM

Work Order ID:	87383		•							
Parent Item:	D412-704-045							Start I	Date: 7/10/12	Required Date: 8/03/12
Parent Item Name:	Cable Assembly (212/2	214/412)						Start	Qty: 4.00	Required Qty: 4.00
D3258-1 Angle Bracket	Ŋ	Manufactured	No			100	Each	21.0000	1	4 (4) FF 12-10-02
				Location	<u>!</u>	Loc Qty		Loc Code		
•				ST035		21				_
				•	76165	4				7
					86489	17				' ~
MS21042L3 Nut	F	Purchased	No			100	Each	3,107.0000	2	8 (4) FF 12-10-02
				Location	!	Loc Qty		Loc Code		8
				ST300	122141	1107				<i>0</i>
					117885	32				_
					119017	757				_
					119075	138				_
					121444	180				_
				ST317		2000				_
					122141	2000				<u> </u>
NAS509-3 Nut	I	Purchased	No			100	Each	42.0000	3	12 (4) FF 12-10-02
				Location	1	Loc Qty		Loc Code		4
				ST280		42				_
					118384	12			-	
					121827	30			12	_

DQA: Date:

NCR:	Yes	1	No
INCN.	162	/	INO

									QA Closed:	Date:		
Work Orde	r•				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	:	
	Part No.			Rework Scrap	4 1	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality Other		
NCR N	R No Work Order Update						Thermoforming Finishing Rec/Store/Packaging Other Large Fab Composite Supplier					
Root				Descri	iption of work order update	Initial	Act	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector	
Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Fraining Unapproved		·										
napproved		<u>.</u>	l			AULT CATE	GORY		l	<u> </u>		
Landin	g Gear				General	AUET CATE						
	Bending Centre N Cracks Crushed	ot Conce		o/s	Bend BOM/Route Broken/Damaged Burrs	Instruc	ion Incomplete tions Incomplete/	Unclear	Ovalized Over/Under Part Incorre	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
-	Cuffs Heat Tre	at		-	Contamination Countersink	Mislab	enance eled	 	Part Moved Positioned V	Vrong		
	Inspection	on Strip in	Tube		Cut Too Short	Misrea			Power Loss/		Other	
-	Ripples i				Drill Holes	Offset						
 	Torque Waves in Extrusion Drawing			Out of Calibration								
	– 1	Turning Sequence Finish				—	Sequence					
	Wave/Tv	Wave/Twist in Tube Folio				Outside	e Dimensions					

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DART SERVICE INSTRUCTION TO AMEND IIN-D412-704 REV. C OR EARLIER

AND ICA-D412-704 REV. 4 OR EARLIER **REF CANADIAN STC SH93-34** REF FAA STC SR00957NY REF EASA STC EASA.IM.R.00696

PURPOSE

The purpose of this Dart Service Instruction is to correct part number error in Installations Instruction IIN-D412-704 Rev. C or earlier and Instructions for Continued Airworthiness ICA-D412-704 Rev. 4 or earlier. The AN3-13A bolt should be replaced with an AN3-10A bolt in Figure 5 - Detail L in IIN-D412-704 and Figure 25-4 Detail L in ICA-D412-704. See sheet 2.

PART LIST CORRECTION

Revise Part Lists in IIN-D412-704 & ICA-D412-704 as follows:

NOW

Qty -043	Qty -045	Part Number	Description
X		D205-704-043	CABLE ASSEMBLY (205)
	X	D412-704-045	CABLE ASSEMBLY (210/212/214/412)
1	1	AN3-10A	BOLT

WAS

Qty -043	Qty -045	Part Number	Description
Х		D205-704-043	CABLE ASSEMBLY (205)
	Х	D412-704-045	CABLE ASSEMBLY (210/212/214/412)
1	1	AN3-13A	BOLT

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION **BRANCH** DAO # 01-O-01

APPROVED

D. SHEPHERD (DE # 02)

DATE: 12.05.07 CERT. NO.: SH93-34 ISSUE NO .:

NEW ISSUE (REF PAR 12.05.07 REV. DESCRIPTION DATE **DESIGN** RF DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA AL. DRAWING NO. CHECKED REV. A DSI 9611 MFG. APPR N/A SHEET 1 OF 2 **APPROVED** TITLE **SCALE** DE APPR. PART NUMBER CORRECTION NTS DATE COPYRIGHT © 2012 BY DART AEROSPACE LTD 12.05.07

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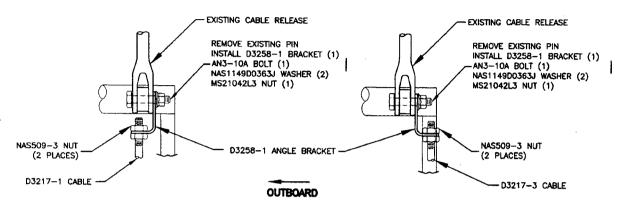
NCONTROLLED COPY BJECT TO AMENDMENT

ENGINEERING

FIGURES CORRECTION

Revise Detail L Figure 5 of IIN-D412-704 and Detail L Figure 25-4 of ICA-D412-704 as follows:

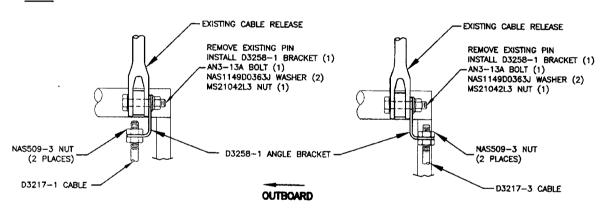
NOW



View Looking Down (Pilot's Side) (-013 Only)

View Looking Down (Pilot's Side) (-011/-015 Only)

WAS



View Looking Down (Pilot's Side) (-013 Only)

View Looking Down (Pilot's Side) (-011/-015 Only)

Figure 5 - Detail L or Figure 25-4 - Detail L

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION **BRANCH** DAO # 01-O-01

APPROVED D. SHEPHERD (DE # 02)

DATE: CERT. NO.: ISSUE NO .: 12.05.07

DESIGN	RF
DRAWN	RF
CHECKED	\$
MFG. APPR.	N/A,
APPROVED	#
DE APPR.	#
DATE 12.0	5.07

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TITLE

HAWKESBURY, ONTARIO, CANADA REV. A SHEET 2 OF 2

SCALE

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